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Cho

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(54) **VACUUM GENERATING DEVICE**

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(73) Assignee: **Korea Pneumatic System Co., Ltd.**, Seoul (KR)

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(51) **Int. Cl.**[7] **F04F 5/52**

(52) **U.S. Cl.** **417/186**; 417/187

(58) **Field of Search** 417/65, 179, 180, 417/182, 187, 186

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(57) **ABSTRACT**

A vacuum generating device designed to generate negative pressure in an absorption means, such as an absorption pad, of a vacuum system, is disclosed. The vacuum generating device accomplishes the recent trend of compactness and smallness of such devices, effectively protects its ejector unit from damage, and does not have an increased production cost in comparison with conventional vacuum generating devices. The vacuum generating device includes a block body having an air inlet port, a vacuum port, and an air outlet port, an ejector unit functioning to generate negative pressure in response to an action of compressed air flowing thereto via the air inlet port, and a control valve mechanism functioning to open or close air supply paths branching from a main flow path to an air inlet chamber of the ejector unit and the vacuum port. The block body has a recess, formed by depressing a surface of the block body to a predetermined depth. The ejector unit is formed in the recess by depressing predetermined portions of the recess. A cover is set in the recess of the block body to seal the ejector unit from the outside.

7 Claims, 8 Drawing Sheets

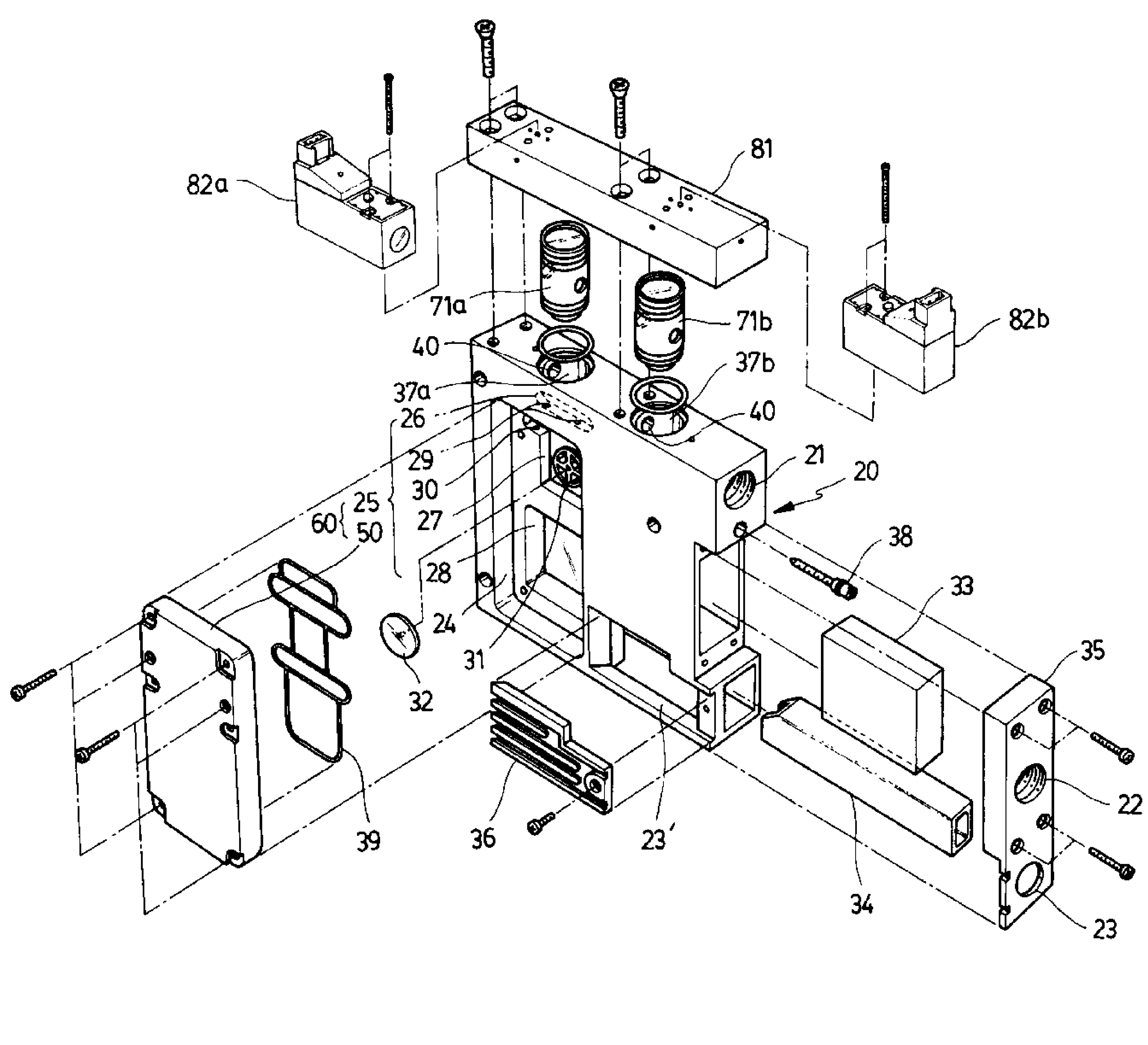


FIG. 1

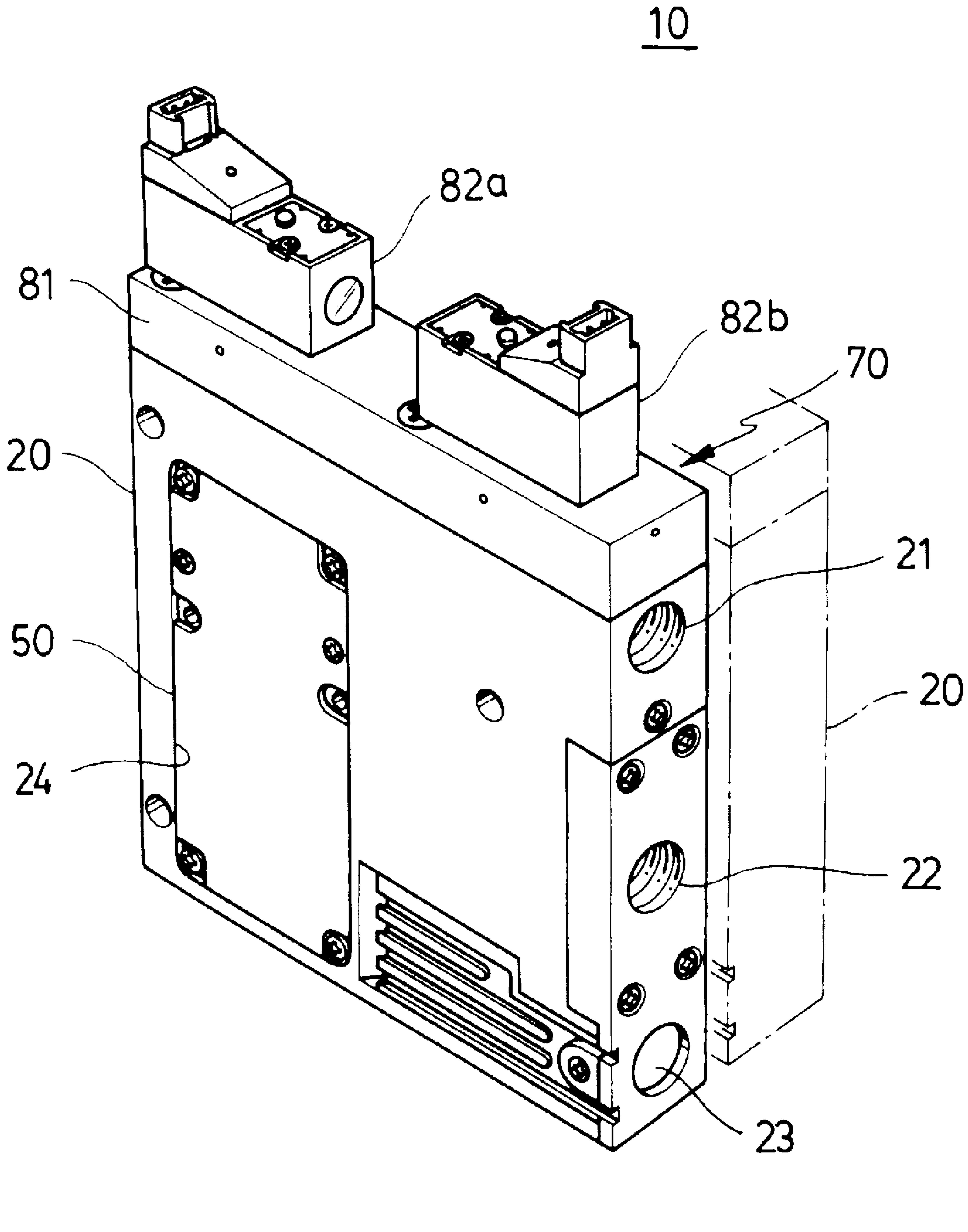
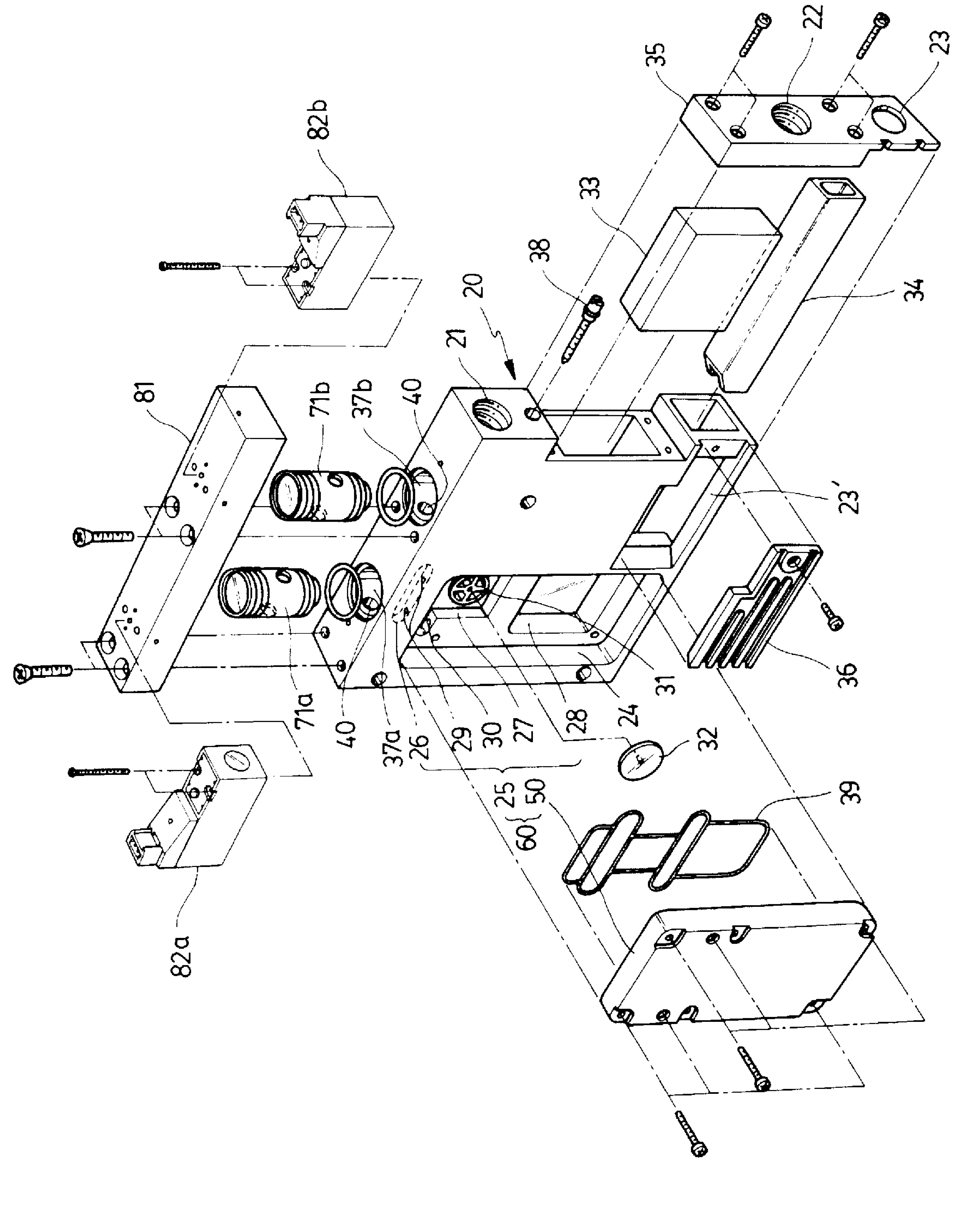


FIG. 2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81
71b
37b
40
21
20
38
33
35
22
23
34
23'
36
31
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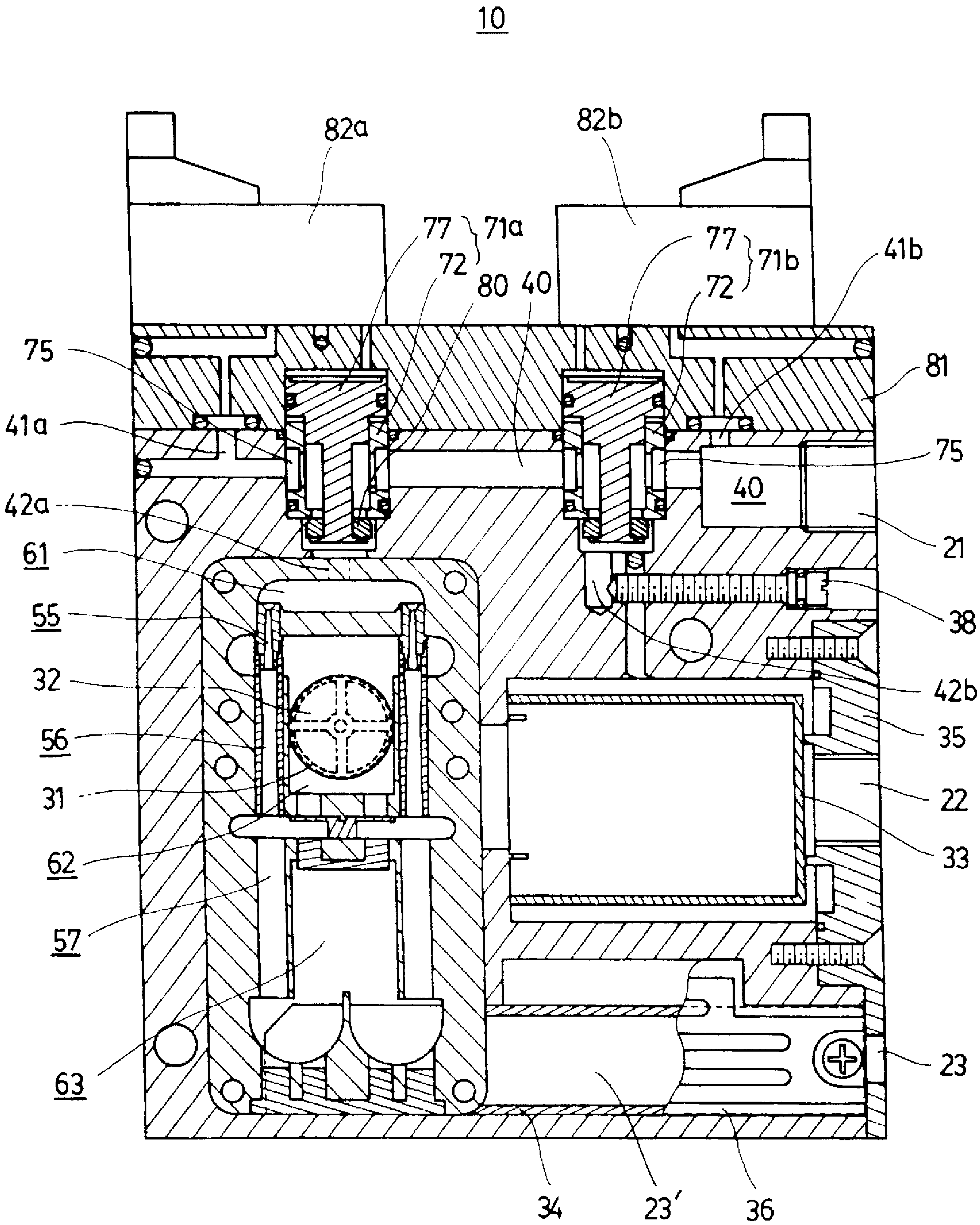
28
27
30
29
26
37a
40
71a
82a
32
25
50
60
39

FIG. 3


10
82a
82b
77
71a
72
80
40
77
71b
72
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81
41a
75
40
42a
21
61
38
55
42b
32
35
56
22
31
33
62
57
23
63
34
23′
36

FIG. 4a

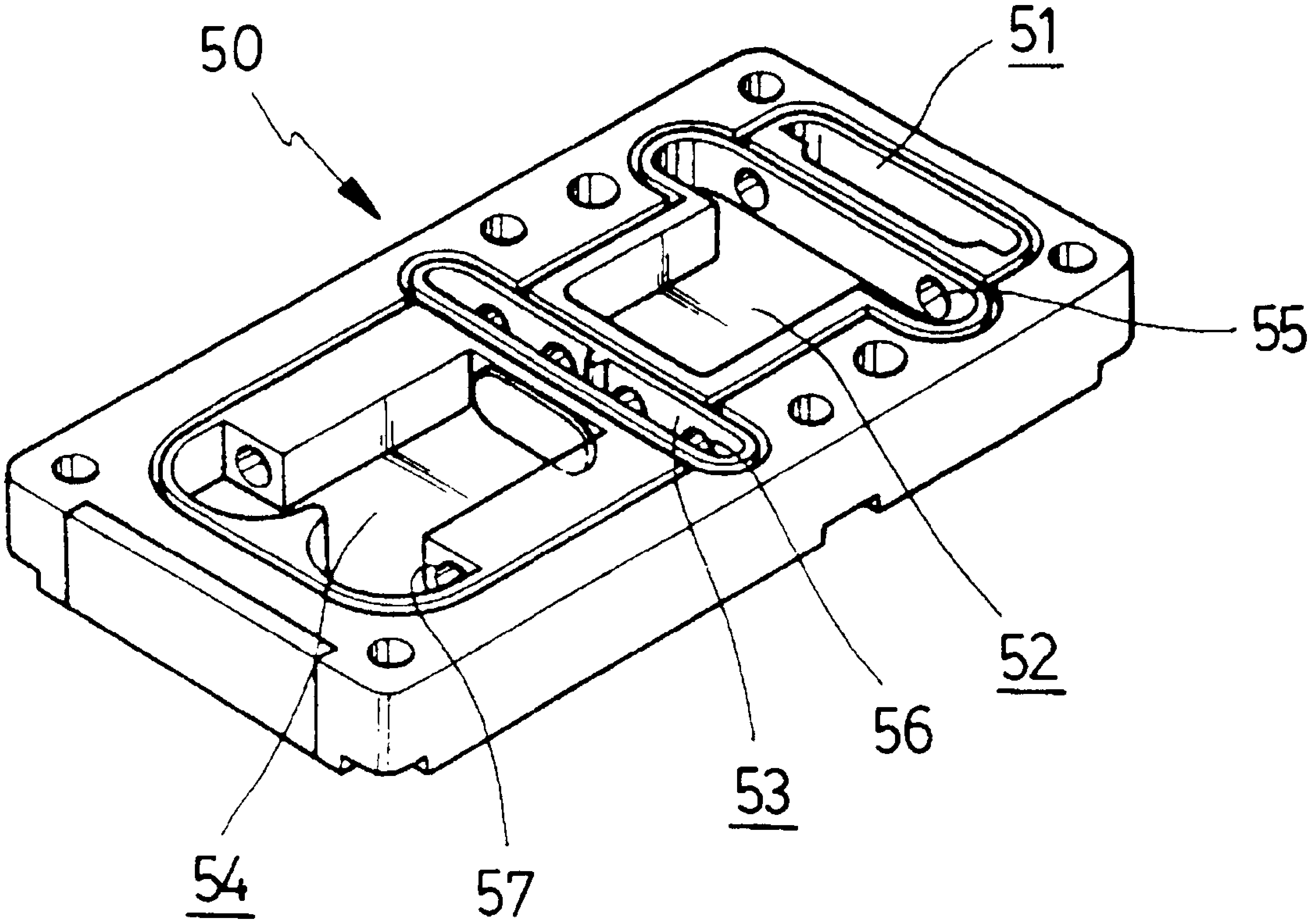


FIG. 4b

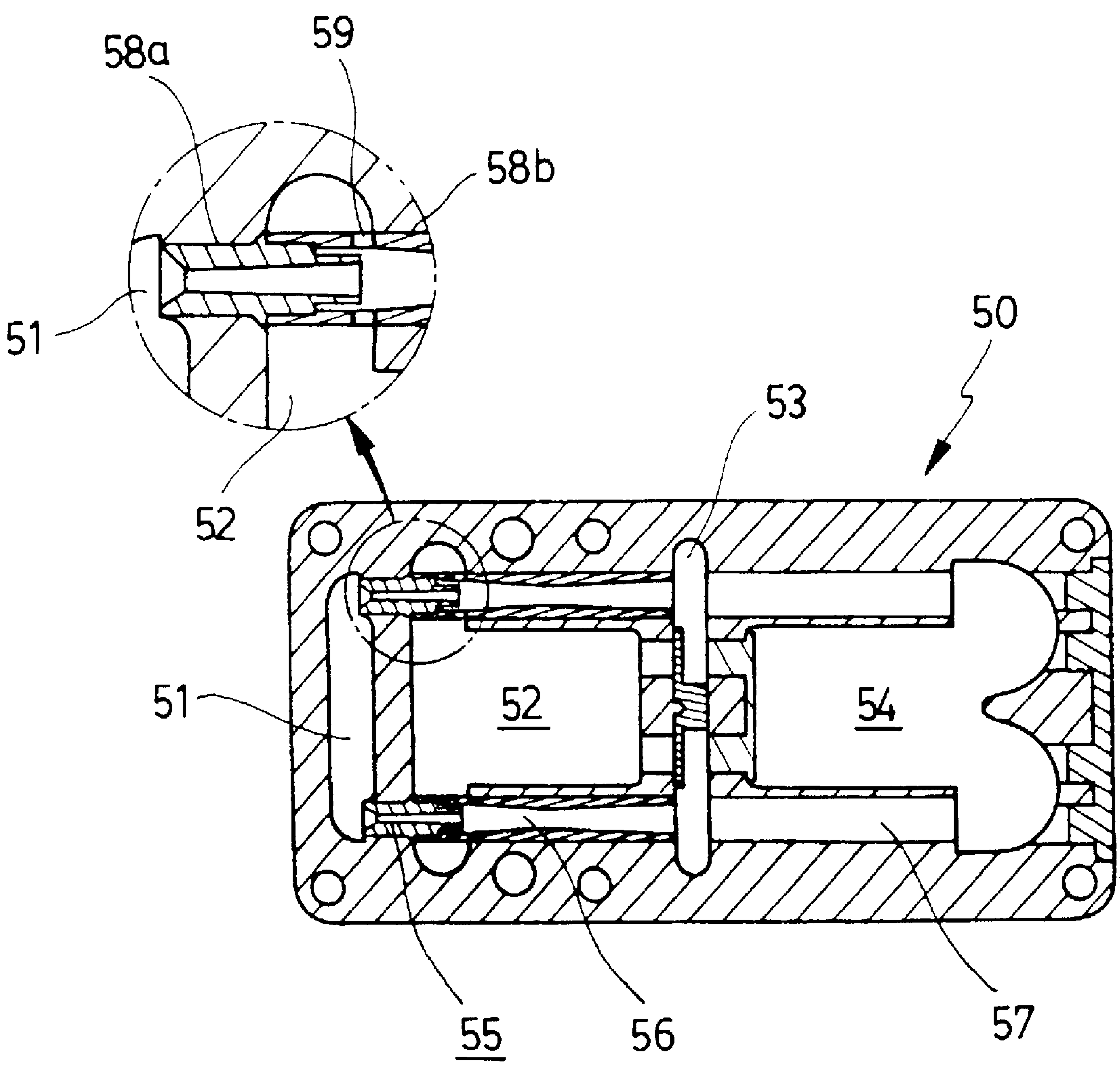


FIG. 5

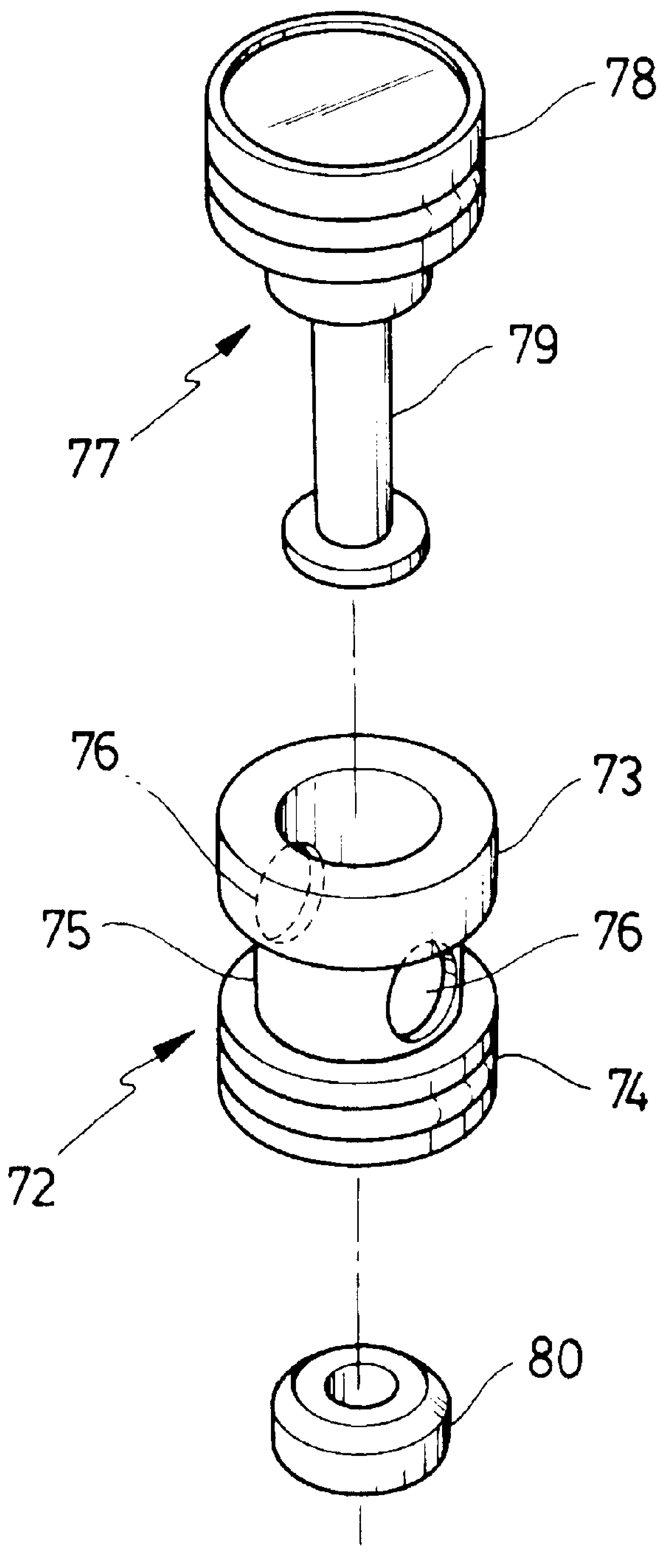


FIG. 6

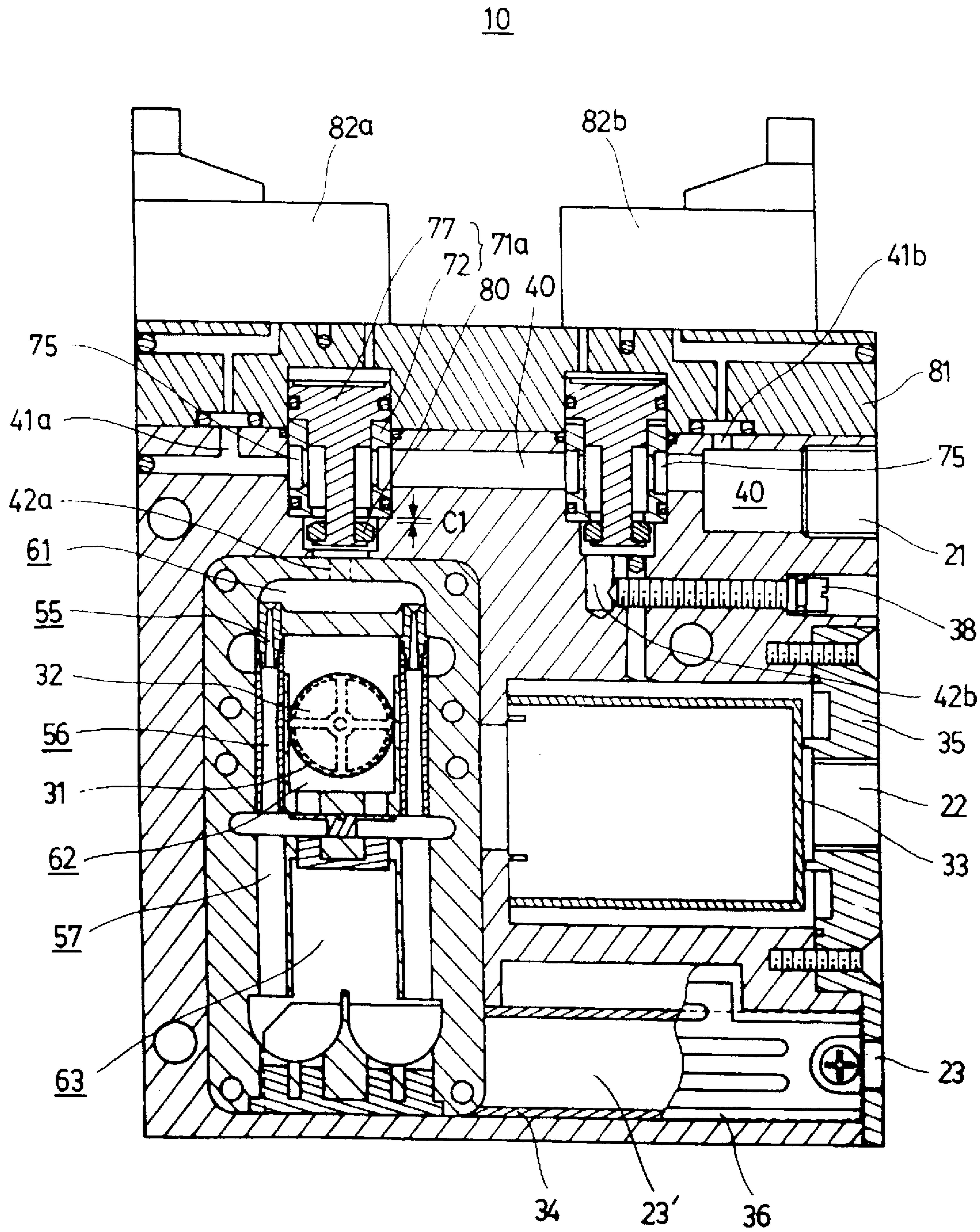
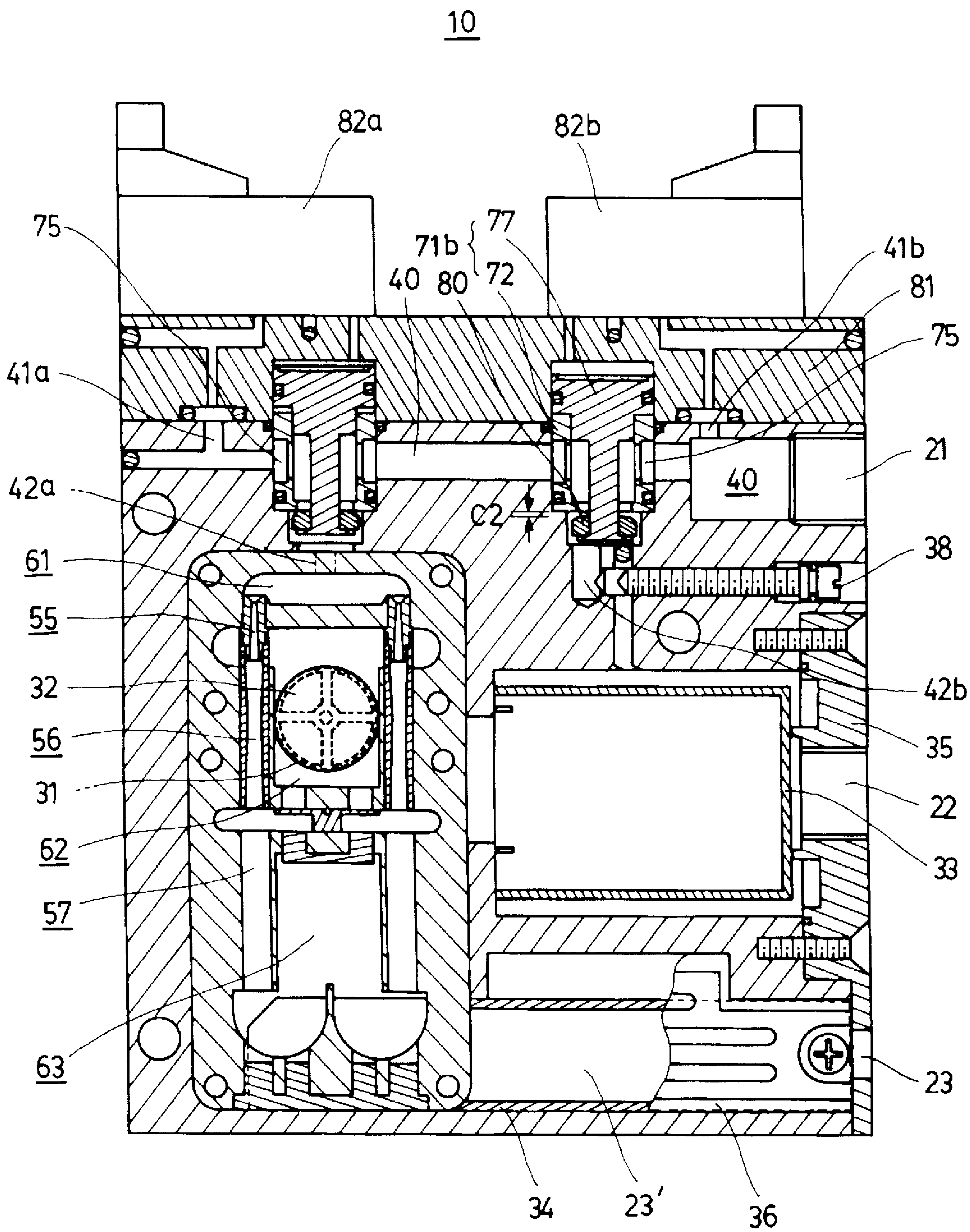

10
82a
82b
77
71a
72
80
40
41b
75
81
41a
75
42a
40
C1
21
61
55
38
32
42b
56
35
31
22
62
33
57
63
23
34
23′
36

FIG. 7


10
82a
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41b
81
75
41a
21
40
42a
C2
38
61
55
42b
32
35
56
31
22
33
62
57
63
23
34
23′
36

VACUUM GENERATING DEVICE

BACKGROUND OF THE INVENTION

1. Field of the Invention

The present invention relates, in general, to vacuum generating devices and, more particularly, to a vacuum generating device designed to generate negative pressure in an absorption means, such as an absorption pad, of a vacuum system, such as a vacuum feeding system used on a production line, and release the negative pressure from the absorption means.

2. Description of the Prior Art

As well known to those skilled in the art, ejectors have been typically used for generating negative pressure in an absorption means in a vacuum system. Such an ejector may be separately installed in a vacuum system, to be used independently. Alternatively, such an ejector may be designed such that it constitutes a vacuum generating device in cooperation with some elements, such as a block body, a valve mechanism, etc., of the vacuum system.

Japanese Patent Laid-open Publication No. Heisei. 11-114862 discloses a typical example of conventional vacuum generating devices for such vacuum systems. The above conventional vacuum generating device comprises a single block body having a compressed air path, an ejector used for generating negative pressure in response to an action of the compressed air, and a control valve mechanism used for opening or closing the compressed air path of the block body. The ejector is provided at a side surface of the block body, while the control valve mechanism is provided in an upper portion of the block body. The vacuum generating device generates negative pressure in an absorption means of a vacuum system, and quickly releases negative pressure from the absorption means, as desired. Therefore, the vacuum generating device may be preferably used in a variety of vacuum systems, such as a vacuum feeding system used in an automated production line to feed workpieces to target places. However, the vacuum generating device is problematic in that the ejector is exposed outside the side surface of the block body, thus undesirably increasing the size of the device and being undesirably and easily removed from the block body by external shock.

In an effort to improve the structure and operational function of conventional vacuum generating devices, such as the above-mentioned Japanese device, U.S. Pat. No. 6,416,295 discloses another vacuum generating device, comprising a main body including four functional blocks arranged longitudinally and continuously, an ejector installed in the main body, and a control valve mechanism provided in an upper portion of the main body. The object of the above U.S. patent is to accomplish the recent trend of compactness and smallness of such vacuum generating devices by reducing the width of the device. However, the vacuum generating device disclosed in the above U.S. patent is problematic in that an undesired increase in the length of the device has resulted even though the device has a reduced width, so that compactness or smallness of the device has not been achieved. Another problem experienced in the vacuum generating device of the above U.S. patent resides in that the number of parts of the device has increased, resulting in an undesired increase in the production cost of the device.

SUMMARY OF THE INVENTION

Accordingly, the present invention has been made keeping in mind the above problems occurring in the prior art, and an object of the present invention is to provide a vacuum generating device, which accomplishes the recent trend of compactness and smallness of such devices, which effectively protects its ejector unit from damage, and does not have an increased production cost in comparison with conventional vacuum generating devices.

In order to accomplish the above objects, the present invention provides a vacuum generating device, comprising a block body having an air inlet port, a vacuum port and an air outlet port, an ejector unit functioning to generate negative pressure in response to an action of compressed air flowing into the ejector unit via the air inlet port, and a control valve mechanism functioning to open or close air supply paths branching from a main flow path to an air inlet chamber of the ejector unit and the vacuum port, the main flow path communicating with the air inlet port.

The present invention is characterized in that the block body has a recess, formed by depressing the surface of the block body to a predetermined depth, the ejector unit is formed in the recess by depressing predetermined portions of the recess, and a cover is set in the recess of the block body to seal the ejector unit from the outside. Preferably, the cover is designed such that its thickness is not greater than the depth of the recess of the block body.

In the present invention, the ejector unit is integrally formed in the block body such that the ejector unit is not exposed to the outside of the block body. Therefore, the vacuum generating device accomplishes the recent trend of compactness and smallness of such devices, and effectively protects its ejector unit from damage.

BRIEF DESCRIPTION OF THE DRAWINGS

The above and other objects, features and other advantages of the present invention will be more clearly understood from the following detailed description taken in conjunction with the accompanying drawings, in which:

FIG. **1** is a perspective view of a vacuum generating device in accordance with a preferred embodiment of the present invention;

FIG. **2** is an exploded perspective view of the vacuum generating device of FIG. **1**;

FIG. **3** is a sectional view of the vacuum generating device of FIG. **1**;

FIGS. **4***a* and **4***b* are views of a cover constituting the vacuum generating device according to the preferred embodiment of the present invention, in which: FIG. **4***a* is a perspective view of the cover, and FIG. **4***b* is a sectional view of the cover;

FIG. **5** is an exploded perspective view of an ON/OFF control valve constituting the vacuum generating device of FIG. **2**;

FIG. **6** is a sectional view showing the operation of the vacuum generating device of FIG. **3**, when a vacuum-on solenoid valve is in an ON-state; and

FIG. **7** is a sectional view showing the operation of the vacuum generating device of FIG. **3**, when a vacuum-off solenoid valve is in an ON-state.

DETAILED DESCRIPTION OF THE INVENTION

Reference should now be made to the drawings, in which the same reference numerals are used throughout the different drawings to designate the same or similar components.

FIG. **1** is a perspective view of a vacuum generating device in accordance with a preferred embodiment of the present invention. As shown in the drawing, the vacuum generating device **10** of the present invention is produced in the form of a module, and comprises a block body **20**, with an air inlet port **21**, a vacuum port **22** and an air outlet port **23** formed on a side surface of the body **20** at upper, middle and lower portions, respectively. A rectangular recess **24**, having a predetermined depth, is formed on a surface of the body **20**, for example the front surface. A cover **50** is set in the recess **24**, and mounted to the block body **20** using setscrews. The vacuum generating device **10** also includes a control valve mechanism **70**. The valve mechanism **70** is installed in the upper portion of the block body **20**.

In the present invention, it is preferred to design the cover **50** such that its thickness does not exceed the depth of the recess **24**. Therefore, the cover **50** completely set in the recess **24** does not project from the surface of the block body **20**. Due to such a limited thickness of the cover **50**, it is possible to avoid a formation of undesired gap between devices **10** when closely arranging the devices **10** into a stack.

The valve mechanism **70** includes a support plate **81** and two solenoid valves **82***a* and **82***b*. The support plate **81** is mounted on the top surface of the block body **20**, while the two solenoid valves **82***a* and **82***b* are mounted on the top surface of the support plate **81**.

As shown in FIG. **2**, an ejector unit **25** is provided in the recess **24**. The ejector unit **25** comprises a first air inlet chamber **26**, a first vacuum chamber **27** and a first air outlet chamber **28** which are formed in the recess **24** by depressing the walls of the recess **24** at predetermined portions, with a plurality of serial nozzle holes **29** and **30** formed in the ejector unit **25** to allow the chambers **26**, **27** and **28** to communicate with each other. The vacuum chamber **27** of the ejector unit **25** communicates with the vacuum port **22**, while the outlet chamber **28** communicates with the outlet port **23**. In such a case, it is preferable to allow the vacuum chamber **27** to communicate with the vacuum port **22** through an orifice **31**. A check valve **32** is installed in the orifice **31** such that the check valve **32** prevents reverse flow of air in a direction from the vacuum chamber **27** to the vacuum port **22**.

The ejector unit **25** creates an ejector pump **60** in cooperation with the cover **50** set in the recess **24** of the block body **20**. The cover **50** set in the recess **24** covers the three chambers **26**, **27** and **28** of the ejector unit **25**. When the cover **50** is set into the recess **24**, a gasket **39** having a specifically designed shape is closely interposed between the cover **50** and the inside wall of the recess **24** to prevent the chambers **26**, **27** and **28** from directly communicating with each other, thus preventing the direct flow of air between the chambers **26**, **27** and **28**.

In the present invention, the cover **50** may be produced in the form of a flat panel. However, in the preferred embodiment of the present invention, the cover **50** is produced in the form of an ejector plate including a second air inlet chamber, a second vacuum chamber and a second air outlet chamber, with a plurality of serial nozzle holes allowing the chambers of the ejector plate-type cover **50** to communicate with each other. FIGS. **4***a* and **4***b* shows in detail the construction of the ejector plate-type cover **50** produced in the form of an ejector plate. In FIGS. **4***a* and **4***b*, the reference numerals **51**, **52**, **53** and **54** denote a second air inlet chamber, a second vacuum chamber, a sub-vacuum chamber and a second air outlet chamber formed on the cover **50**, respectively. The reference numerals **55**, **56** and **57** respectively denote nozzle holes, allowing the chambers **51**, **52**, **53** and **54** to communicate with each other. The cover **50** preferably includes first and second nozzle spouts **58***a* and **58***b* which are set in two nozzle holes **55** and **56**, respectively, such that the nozzle spouts **58***a* and **58***b* are coupled to each other in the vacuum chamber **52**. A plurality of radial holes **59** are formed in the sidewall of the second nozzle spout **58***b* at positions around the coupled junction of the two spouts **58***a* and **58***b*. When the cover **50** is completely set in the recess **24** of the block body **20**, the inlet chamber **51**, vacuum chamber **52** and outlet chamber **54** of the cover **50** coincide and communicate with the inlet chamber **26**, vacuum chamber **27**, and the outlet chamber **28** of the ejector unit **25**, respectively.

Therefore, in the ejector pump **60** created by both the ejector unit **25** and the ejector plate-type cover **50** according to the preferred embodiment, several chambers **61**, **62** and **63** functioning as an air inlet chamber, a vacuum chamber, and an air outlet chamber have volumes larger than those of an ejector pump having a panel-type cover, as shown in FIG. **3**. Due to the enlarged volumes of the chambers **61**, **62** and **63**, the ejector pump **60** creates a high level of vacuum. In the ejector pump **60**, the chambers **26**, **27** and **28** of the ejector unit **25** communicate with each other through the nozzle holes **55**, **56** and **57** of the cover **50**, so that the ejector unit **25** may be not formed with the nozzle holes **29** and **30** which are separately holed in the unit **25** to allow the chambers **26**, **27** and **28** to communicate with each other. The two nozzle spouts **58***a* and **58***b* also preferably allow the pump **60** to more quickly create desired vacuum.

In the drawings, the reference numeral **33** denotes a dust collecting filter that is set in the vacuum port **22**, and the reference numeral **34** denotes a sound absorbing filter that is set in the outlet port **23**. A filter cap **35** is preferably mounted to the side surface of the block body **20** so as to hold the two filters **33** and **34** in their positions inside the two ports **22** and **23** without allowing an undesired removal of the filters **33** and **34** from the block body **20**. In such a case, the vacuum port **22** and the outlet port **22** and **23** are formed in the filter cap **35**, in place of the side surface of the block body **20**. The reference numeral **36** denotes a cover which covers a part of another outlet port **23**'.

Two valve bores **37***a* and **37***b* are vertically formed on the upper surface of the block body **20** at two spaced positions, such that the bores **37***a* and **37***b* perpendicularly meet a main flow path **40** which is formed in the block body **20** while axially extending from the inlet port **21**. The first bore **37***a*, positioned at the left side of the body **20**, communicates with the inlet chamber **26** of the ejector unit **25** via a first communication hole **42***a* which extends downward from the bottom of the first bore **37***a* to the inlet chamber **26**. In the same manner, the second bore **37***b*, positioned at the right side of the body **20**, communicates with the vacuum port **22** of the block body **20** via a second communication hole **42***b* which extends downward from the bottom of the second bore **37***b*, as shown in FIG. **3**. Therefore, compressed air introduced into the vacuum generating device **10** via the inlet port **21** may flow to the inlet chamber **26** of the ejector unit **25** and the vacuum port **22** through the first and second communication holes **42***a* and **42***b*, respectively. In the vacuum generating device **10**, the two communication holes **42***a* and **42***b* thus respectively constitute compressed air supply paths for the inlet chamber **26** of the ejector unit **25** and the vacuum port **22**. However, the flow of inlet compressed air inside the vacuum generating device **10** is controlled by an operation of the valve mechanism **70** such that the inlet compressed air selectively flows to only one of the inlet chamber **26** and the vacuum port **22**. That is, the valve mechanism **70** controllably opens or closes the first and second communication holes **42** and **42***b* which respectively branch from the main flow path **40** to the inlet chamber **26** of the ejector unit **25** and the vacuum port **22**. In the drawings, the reference numeral **38** denotes a control screw that is threaded into the block body **20** to allow a user to adjust the opening ratio of the second communication hole **42***b* to control the speed of releasing vacuum from the vacuum chamber **62**, as desired.

The construction and operation of the control valve mechanism **70** will be described herein below. However, it should be understood that the construction of the valve mechanism **70** may be altered without being limited to the following construction, if the alteration does not affect the functioning of the present invention.

The control valve mechanism **70** comprises two ON/OFF control valves **71***a* and **71***b* that are set in the two valve bores **37***a* and **37***b*, respectively. The control valve mechanism **70** also includes the support plate **81** and two solenoid valves **82***a* and **82***b*. The support plate **81** is mounted to the top surface of the block body **20**, such that the plate **81** receives the upper portions of the two ON/OFF control valves **71***a* and **71***b*. Of the two solenoid valves **82***a* and **82***b* mounted on the top surface of the support plate **81**, the former **82***a* functions as a vacuum-on solenoid valve, while the latter **82***b* functions as a vacuum-off solenoid valve.

In the present invention, the two ON/OFF control valves **71***a* and **71***b* are pneumatic control valves that are pneumatically operated to change their state from a normal OFF-state to an ON-state. The two solenoid valves **82***a* and **82***b* are normally closed-type solenoid valves.

As shown in FIG. **5**, each of the two ON/OFF control valves **71***a* and **71***b* comprises a cylindrical retainer **72** and a valve body **77** which may be assembled with each other into a single body. The retainer **72** is an integrated cylindrical body, which is hollowed along its central axis, with upper and lower end parts **73** and **74** having the same outer diameter, and an intermediate part **75** having an outer diameter smaller than that of the two end parts **73** and **74**. An opening **76** is formed at a sidewall of the intermediate part **75**. The valve body **77** is an integrated member, including a valve head **78** and a valve stem **79**. The diameter of the valve head **78** is determined such that the head **78** is seated on the top end of the retainer **72**. The valve stem **79** integrally extends downward from the center of the valve head **78** such that the valve stem **79** movably and axially passes the central bore of the retainer **72**. A rubber ring **80** is fitted over the lower end of the valve stem **79**, and has a diameter capable of allowing the ring **80** to seal the lower end of the central bore of the retainer **72** in a normal state.

As shown in FIG. **3**, the retainer **72** of each valve **71***a*, **71***b* is installed in an associated valve bore **37***a*, **37***b* such that the upper and lower end parts **73** and **74** are in close contact with the inner surface of the bore **37***a*, **37***b* while the valve body **77** is installed in the valve bore **37***a*, **37***b* such that it is linearly movable within a predetermined range in a vertical direction. In such a case, the intermediate part **75** of each retainer **72** is positioned at the same level as the main flow path **40** extending horizontally from the inlet port **21**. Therefore, the intermediate parts **75** of the retainers **72** do not block the main flow path **40**. In a normal state of the two ON/OFF control valves **71***a* and **71***b*, the lower ends of the retainers **72** are closed by the rubber rings **80** of the valve bodies **77**, so that the first and second communication holes **42***a* and **42***b*, in a normal state of the valves **71***a* and **71***b*, are closed.

As described above, the two ON/OFF control valves **71***a* and **71***b* are pneumatic control valves that are pneumatically operated to change their state from a normal OFF-state to an ON-state. In order to pneumatically actuate the two ON/OFF control valves **71***a* and **71***b*, the main flow path **40** has two branch paths **41***a* and **41***b* that supply compressed air to the top surfaces of the valve heads **78** of the two ON/OFF control valves **71***a* and **71***b*, respectively. The two normally closed-type solenoid valves **82***a* and **82***b* are installed at positions where the solenoid valves **82***a* and **82***b* control the first and second branch paths **41***a* and **41***b*, respectively. In a detailed description, the first branch path **41***a* primarily extends upwardly from the main flow path **40** in a vertical direction at a left side of the block body **20**, upwardly passes the support plate **81**, passes the vacuum-on solenoid valve **82***a* in an ON-state, and finally passes downwardly the support plate **81** until the path **41***a* communicates with the top surface of the valve head **78** of the first ON/OFF control valve **71***a*. In the same manner, the second branch path **41***b* primarily extends upwardly from the main flow path **40** in a vertical direction at a right side of the block body **20**, upwardly passes the support plate **81**, passes the vacuum-off solenoid valve **82***b* in an ON-state, and finally passes downwardly the support plate **81** until the path **41***b* communicates with the top surface of the valve head **78** of the second ON/OFF control valve **71***b*. Since the two solenoid valves **82***a* and **82***b* are normally closed-type solenoid valves as described above, the two branch paths **41***a* and **41***b* are maintained at their closed states during a normal state of the two solenoid valves **82***a* and **82***b*.

In order to use the vacuum generating device **10** of the present invention, an absorption means (not shown) of a vacuum system is connected to the vacuum port **22** of the device **10**, while an external compressed air source (not shown) is connected to the inlet port **21** of the device **10**. When the vacuum-on solenoid valve **82***a* is switched into its ON-state, compressed air is fed to the main flow path **40** through the inlet port **21**, and passes through the first branch path **41***a* to impose pneumatic pressure to the top surface of the valve head **78** of the first ON/OFF control valve **71***a*. The valve body **77** of the first ON/OFF control valve **71***a* moves downward by a predetermined distance, so that a clearance **C1** is created between the rubber ring **80** and the lower end of the central bore of the retainer **72** of the valve **71***a*, as shown in FIG. **6**. Therefore, inlet compressed air in the main flow path **40** sequentially passes through the opening **76** formed at the sidewall of the intermediate part **75** of the retainer **72**, the clearance **C1**, and the first communication hole **42***a*, thus being fed to the inlet chamber **61** of the ejector pump **60**. The compressed air in the inlet chamber **61** sequentially flows through the nozzle holes **55**, **56** and **57** to pass the vacuum chamber **62** and the outlet chamber **63**, thus being discharged from the device **10** to the outside via the outlet port **23**. During such an operation of the vacuum generating device **10**, air in the absorption means, such as an absorption pad connected to the vacuum port **22**, is sucked into the vacuum chamber **62** through the orifice **31**, and is discharged from the device **10** to the outside along with the compressed air. Desired vacuum is thus created in the vacuum chamber **62**, so that desired negative pressure is generated in the absorption means and allows the absorption means to take a target material, such as a workpiece.

On the other hand, when the vacuum-off solenoid valve **82***b* is switched into its ON-state, compressed air in the main flow path **40** passes through the second branch path **41***b* to impose pneumatic pressure to the top surface of the valve head **78** of the second ON/OFF control valve **71***b*. The valve body **77** of the second ON/OFF control valve **71***b* moves downward by a predetermined distance, so that a clearance

C2 is created between the rubber ring **80** and the lower end of the central bore of the retainer **72** of the valve **71***b*, as shown in FIG. **7**. Therefore, inlet compressed air in the main flow path **40** sequentially passes through the opening **76** formed at the sidewall of the intermediate part **75** of the retainer **72**, the clearance C**2**, and the second communication hole **42***b*, thus being fed to the vacuum port **22**. Therefore, vacuum is quickly eliminated from the vacuum chamber **62**, so that negative pressure is released from the absorption means. In the vacuum generating device **10** of the present invention, it is possible to adjust the vacuum releasing speed by appropriately tightening or loosening the control screw **38** relative to the body **20** such that the opening ratio of the second communication hole **42***b* is adjusted by the inside end of the control screw **38**.

As described above, the present invention provides a vacuum generating device preferably used in a variety of vacuum systems, such as a vacuum feeding system. In the vacuum generating device of the present invention, an ejector unit is integrally formed in a block body by recessing a surface of the block body at a predetermined portion. A cover covers the ejector unit, thus preventing exposure of the ejector unit to the outside of the block body. Therefore, the vacuum generating device of this invention accomplishes the recent trend of compactness and smallness of such devices, effectively protects its ejector unit from damage, and does not increase its production cost in comparison with conventional vacuum generating devices.

Although a preferred embodiment of the present invention has been described for illustrative purposes, those skilled in the art will appreciate that various modifications, additions and substitutions are possible, without departing from the scope and spirit of the invention as disclosed in the accompanying claims.

What is claimed is:

1. A vacuum generating device, comprising a block body having an air inlet port, a vacuum port and an air outlet port; an ejector unit functioning to generate negative pressure in response to an action of compressed air flowing into the ejector unit via the air inlet port; and a control valve mechanism functioning to open or close air supply paths branching from a main flow path to an air inlet chamber of the ejector unit and the vacuum port, said main flow path communicating with the air inlet port, wherein

said block body has a recess, said recess being formed by depressing a surface of the block body to a predetermined depth;

said ejector unit comprises a first air inlet chamber, a first vacuum chamber and a first air outlet chamber which are formed in said recess by depressing predetermined portions of the recess and respectively communicate with the air inlet port, the vacuum port and the air outlet port of said block body, with communicating means for allowing the first air inlet chamber, first vacuum chamber, and the first air outlet chamber to communicate with each other; and

a cover is set in said recess of the block body to seal the first air inlet chamber, first vacuum chamber, and the first air outlet chamber of the ejector unit from the outside.

2. The vacuum generating device according to claim **1**, wherein said communicating means comprises a plurality of serial nozzle holes formed in the ejector unit such that the nozzle holes allow the first air inlet chamber, first vacuum chamber, and the first air outlet chamber to communicate with each other.

3. The vacuum generating device according to claim **1**, wherein said cover comprises an ejector plate-type cover, with a second air inlet chamber, a second vacuum chamber and a second air outlet chamber formed on the cover so as to correspond to and coincide with the first air inlet chamber, the first vacuum chamber, and the first air outlet chamber of the ejector unit, respectively, said cover also having a plurality of serial nozzle holes allowing the second air inlet chamber, second vacuum chamber, and the second air outlet chamber to communicate with each other.

4. The vacuum generating device according to claim **1**, wherein said cover has a thickness not greater than the depth of said recess of the block body.

5. The vacuum generating device according to claim **3**, wherein said cover is provided with two nozzle spouts, said nozzle spouts being set in the nozzle holes of the cover, respectively, such that the nozzle spouts are coupled to each other in the second vacuum chamber of the cover, with a hole formed in a sidewall of the nozzle spouts at a position around a coupled junction of said two nozzle spouts.

6. The vacuum generating device according to claim **2**, wherein said cover has a thickness not greater than the depth of said recess of the block body.

7. The vacuum generating device according to claim **3**, wherein said cover has a thickness not greater than the depth of said recess of the block body.

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